



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-2-1
Job Sheet 191775



Part No: C45-2-1

Job Qty: 8 pcs

Part Name: Sideplate - MRK



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C45-2-1 REV 11 IPP REV A 18.02.13 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs	4/30/19	4/30/19	0.00	1.33	Bandsaw - 1		J.C.L.
120	NV5000 - 1 - B4B	8 pcs	4/30/19	4/30/19	2.00	8.00	NV5000 - 1 - B4B		
							NV5000 - 2 - B4B		J.C.L.
130	QC 2	8 pcs	4/30/19	4/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.L. 19-03-24
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S164654



Part: C45-2-1

Job No: 191775

Serial No/Batch: S164654

Revision: 11

Inspector:

Exp Date:

Instructions:

Date: 03/21/19

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
140	QC 8	8 pcs	4/30/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
150	Outsource - 4 - Anodize	8 pcs	4/30/19	0.00 0.00	
160	Packaging 2-1 - Receive - B4B	8 pcs	4/30/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B

5/21/04/14

04/15/2019 DC

DP APR 22 2019

				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	8 pcs	4/30/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	DAS
				QC 6 - 68	APR 23 2019 68
				QC 6 - 61	9-89
180 Packaging 3-1 - Stock - B4B	8 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	8 pcs	4/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS APR 24 2019
				QC 21 - SA - 53	21
Part Op 100 - (Bandsaw) 1- Cut 9.325" long Descriptions: 120 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FC313 FOLIO REV: _____ DWG REV: _____ 2- Machine Engrave S/N *** SEE PEC EVERY TIME FOR CHANGE BATCH **** 3-Debur 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 150 - Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATC: 043202 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required 160 - Receive & Inspect for Damage & Mat'l Certs) Receive 170 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location: _____) Identify and Stock 190 - (QC21- Final Inspection - Work Order Release)					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X8.000	7075-T6 Sheet 1.000" X 8.000"	6.2160 ft (.777 ea)	100-Bandsaw - 1	S129 444 S081264
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.000X8.000	6	27	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order:	191775
Description: Side plate		Part Number:	C45-2-1
Inspection Dwg: C45-2-1	Rev: 11	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.177	+0.005 -0.001	.177	✓		Caliper	J.C.-L-08
W 0.1882	+0.0005 -0.0000	0.1882	✓		Pin Gauge	
± 0.55	±0.010	0.560	✓		Caliper	
Ø 0.3125	+0.005 -0.000	0.313	✓			
Ø 0.500	+0.005 -0.000	0.501	✓			
Ø 0.625	+0.0005 -0.0000	0.625	✓		Mic.	JCL-01
W 0.750	+0.001 -0.001	0.750	✓			
± 0.540	+0.003 -0.000	0.540	✓			
Ø 0.2513	+0.0004 -0.0000	0.2513	✓		Pin Gauge	
± 0.700	±0.005	0.710	✓			
Ø 0.8751	+0.0003 -0.0000	0.8753	✓		Mic.	JCL-01
W 1.000	+0.010 -0.000	1.000	✓			
± 0.475	+0.003 -0.000	0.477	✓			
Ø 1.0000	+0.0005 -0.0000	1.0001	✓			
W 1.125	+0.012 -0.000	1.125	✓			
± 0.520	+0.003 -0.000	0.522	✓			
Ø 0.625	+0.003 -0.001	0.625	✓			
± 0.760	±0.005	0.760	✓			
W 0.905	+0.0005 -0.0000	0.9053	✓			
± 0.720	+0.003 -0.000	0.722	✓			
Ø 0.6250	+0.0005 -0.0000	0.625	✓			
W 0.750	+0.010 -0.000	0.750	✓			
± 0.470	+0.003 -0.000	0.472	✓			
9.13	±0.010	9.130	✓			
7.82	±0.010	7.820	✓			
0.840	±0.005	0.843	✓			
0.540	±0.005	0.545	✓			
0.400	+0.003 -0.000	0.402	✓			

Measured by: J.C.L.	Checked by: [Signature]	QC Inspector:
Date: 14-07-23	Date: 19/04/24	Date:

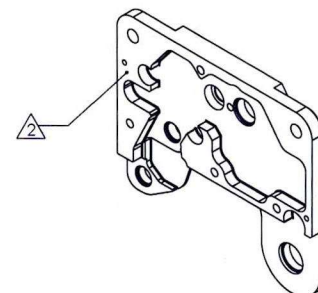
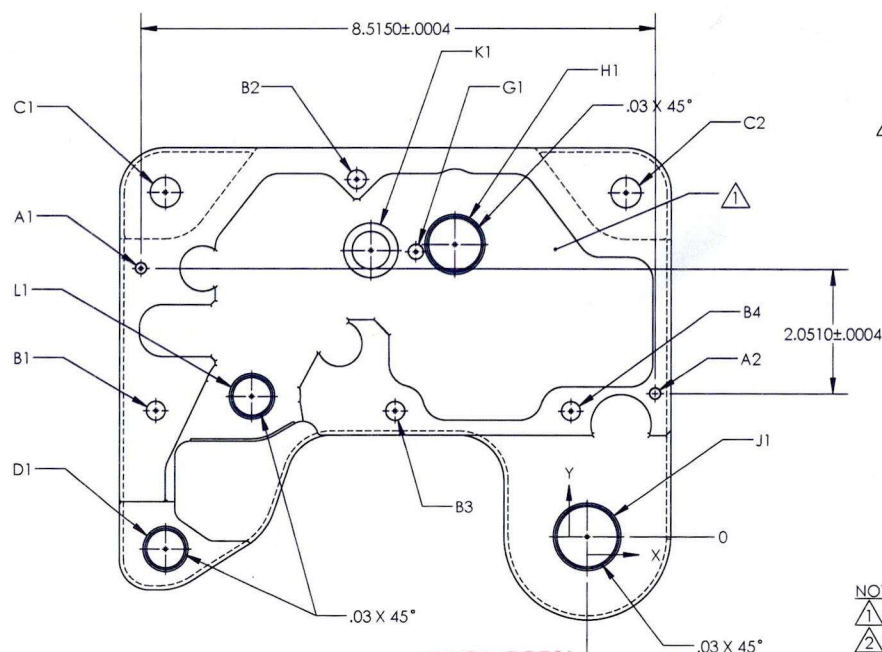
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		AS DRAWN BY CANAM.	9/11/2012	JAG	
8		CHANGED HOLE SIZE FOR HOLES A1-2, C1-2, H1, & K1 FOR A BETTER FIT.	10/29/2012	JAG	
9	14-0126	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE: CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/13/2014	DPD	RW
10	15-0226	UPDATED HOLE TABLE WAS D2 IS L1, DELETED HOLES E1 & E2, CH'D DIM G1 WAS $\varnothing .2505-.2508 \nabla .300$ IS $\varnothing .2513-.2522 \nabla .700$, CH'D HOLE ∇ TO BE CALLED FROM SAME SURFACE, D1 WAS $\varnothing .070+.003-.000$ IS $\varnothing .540+.003-.000$, H1 WAS $\varnothing .075+.003-.000$ IS $\varnothing .475+.003-.000$, J1 WAS $\varnothing .120+.003-.000$ IS $\varnothing .520+.003-.000$, K1 WAS $\varnothing .360$ IS $\varnothing .760$, WAS $\varnothing .320+.005-.000$ IS $\varnothing .720+.005-.000$, ADDED HOLE ∇ NOTE, DELETED UNNECESSARY DIMS SHEET 2, CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	9/10/2015	DPD	JAG
11	17-0117	UPDATED TO NEW STANDARDS, CH'D DIM WAS $\varnothing .177$ THRU ALL $\varnothing .1880+.0005/-0.0000 \nabla .55$ IS $\varnothing .177$ THRU ALL $\varnothing .1882+.0005/-0.0000 \nabla .55$, REMOVED DIM 1.125, 2.379, ADDED DIM 8.5150 $\pm .0004$, 8.5150 $\pm .0004$.	5/10/2017	SM	JAG

TAG	X LOC	Y LOC	SIZE
A1	-7.390	4.430	$\varnothing .177$ THRU ALL
A2			$\varnothing .1882^{+.0005}_{-.0000} \nabla .55$
B1	-7.142	2.087	
B2	-3.818	5.913	$\varnothing .3125^{+.0050}_{-.0000}$ THRU ALL
B3	-3.177	2.087	
B4	-.273	2.087	
C1	-6.989	5.695	$\varnothing .500^{+.005}_{-.000}$ THRU ALL
C2	.636	5.695	
D1	-6.977	-.213	$\varnothing .6250^{+.0005}_{-.0000}$ THRU ALL $\varnothing .750 \nabla .540^{+.003}_{-.000}$
G1	-2.842	4.709	$\varnothing .2522 \nabla .700$ $\varnothing .2513$
H1	-2.194	4.833	$\varnothing .8754$ THRU ALL $\varnothing .8751$ $\varnothing 1.000 \nabla .475^{+.003}_{-.000}$
J1	-.000	.000	$\varnothing 1.0000^{+.0005}_{-.0000}$ THRU ALL $\varnothing 1.125 \nabla .520^{+.003}_{-.000}$
K1	-3.582	4.734	$\varnothing .625 \nabla .760$ $\varnothing .9055 \nabla .720^{+.005}_{-.000}$ $\varnothing .9050$
L1	-5.550	2.326	$\varnothing .6250^{+.0005}_{-.0000}$ THRU ALL $\varnothing .750 \nabla .470^{+.003}_{-.000}$



NOTES:

- 1 MACHINE ENGRAVE BATCH NUMBER.
- 2 HOLE ∇ CALLED FROM THIS SURFACE.

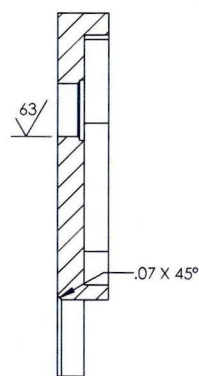
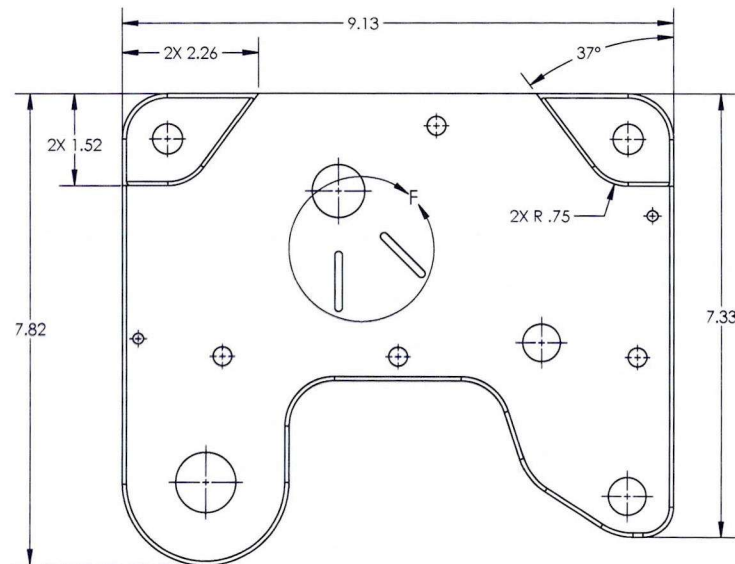
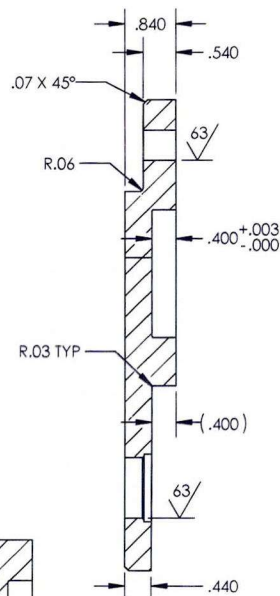
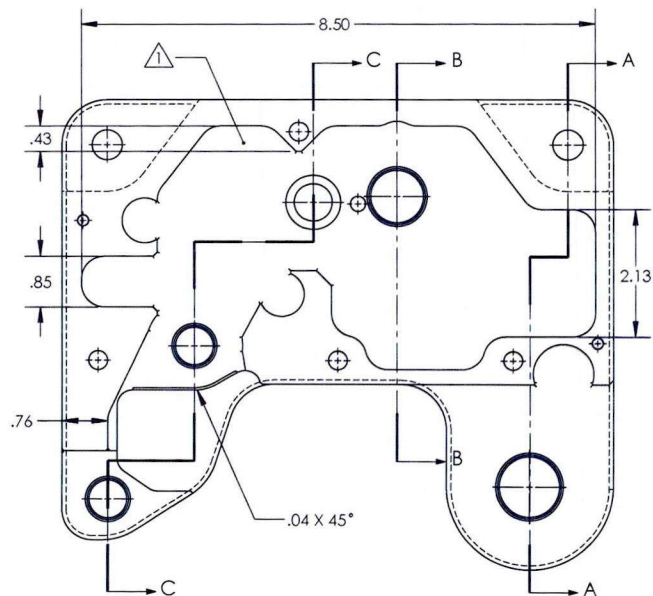
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191775 MWS
19-0308

DART AEROSPACE	
TITLE SIDE PLATE	
DWG NO C45-2-1	REV 11
MAT'L 7075-T6 TREAT FINISH BLACK ANODIZE SPEC MIL-A-8625, TYPE II, CLASS II DRAWN BY: CANAM CHECKED: RJC 05/10/2017 ORPS APPR: AA 05/17/2017 QA APPR: JL 05/17/2017 APPROVED: JAG 05/17/2017	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125/✓ 1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
SCALE 1:2	DATE 4/10/2003
SHEET 1 OF 2	

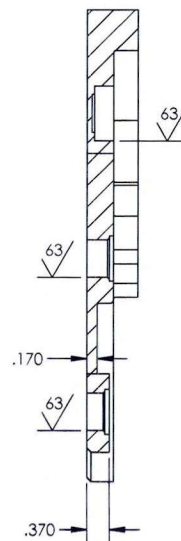
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-2-1	1	SIDE PLATE	7075-T6	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
10	15-0226	DELETED UNNECESSARY DIMS.	9/10/2015	DPD
			APPROVED	JAG

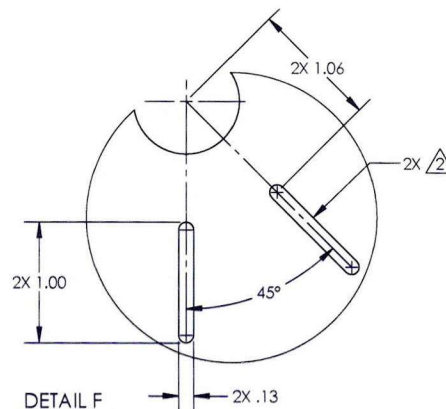


SECTION B-B



SECTION C-C

SECTION A-A



DETAIL F
SCALE 1:1

- NOTES:
- USE DXF PROFILE FOR POCKET DETAILS.
 - LASER ETCH PATTERN.

DART AEROSPACE	
TITLE SIDE PLATE	
DWG NO. C45-2-1	
REV 11	
MAT'L 7075-T6	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625, TYPE II, CLASS II	.XX ± .01 ANGLES ± 5°
DRAWN BY: CANAM	.X ± .1 SURFACES ± 125/
CHECKED: RJC 05/10/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 05/17/2017	.015 X 45° OR .015R
QA APPR: JL 05/17/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 05/17/2017	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M 2009
	USED ON MODEL
SCALE 1:2	DATE 4/10/2003
	SHEET 2 OF 2

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

PO043202



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043202
PO Date: 4/15/19
Due Date: 4/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191527	RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93- 3205-00E Rev. 2A	Firmed X8	-	4/22/19	8 pcs	0 pcs	8 pcs	\$15.00/pcs	\$120.00
2	191771	C45-11-1	Sideplate, Solenoid Side (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to Groupe Altech : -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed X10	-	4/22/19	10 pcs	0 pcs	10 pcs	\$6.75/pcs	\$67.50



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043202



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191775	C45-2-1	Sideplate - MRK Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	4/22/19	11 pcs	0 pcs	11 pcs	\$6.75/pcs	\$74.25

X11 APR 22 2019 DP

Grand Total: \$261.75

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/16/19 9:25 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018516-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018516 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Apr-2019		SPARTAKOS BOUNTOURIS		PO043202				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3205-00E Rev.	RBE350A93-3205-00E ANODIZE RED PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	0
2	C45-11-1 Rev.	C45-11-1 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0
3	C45-2-1 Rev.	C45-2-1 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	11	11	0	0	0

Notes Additionnelles / Additional Notes

3 boîtes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.